



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200



D412-664-203TRN
Job Sheet 173474



Part No: D412-664-203TRN

Job Qty: 1 ea

Part Name: Crosstube Turning Detail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/23/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV F IPP Rev:A 08-03-06 new issue DD verified by:eec IPP Rev B 08.04.02 Removed polish EC verified by: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/22/18	3/22/18	0.00	0.00	Start Up Crosstubes-2		MD
100	Mori Seiki	1 pcs	3/22/18	3/22/18	3.21	1.33	Mori Seiki TL-40		MD DASH
110	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC2-3		MD 58
120	Mori Seiki	1 pcs	3/22/18	3/22/18	0.00	1.67	Mori Seiki TL-40		MD 18/09/18
130	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC2-3		MD 18/09/18
140	QC	1 pcs	3/22/18	3/22/18	0.00	0.00	QC8		SP 18/09/18
145	Crosstubes	1 pcs	3/22/18	3/22/18	0.00	0.25	Crosstubes-2		SP 2018-09-09
150	HandFXtube	1 pcs	3/23/18	3/23/18	0.00	0.92	HandFinish5		DR 18/09/18
160	QC	1 pcs	3/23/18	3/23/18	0.00	0.00	QC7-3		SP 2018-09-05
170	Packaging	1 pcs	3/23/18	3/23/18	0.00	0.00	Packaging3-2		OPZ SEP 1
180	QC21-SA	1 Ea	3/23/18	3/23/18	0.00	0.00	QC21		21

Part Op 100 - 1-Fill tube with sand & install plugs 412-203 on both ends as per Folio FA166 2-Face both sides of tube 3-Turn first Descriptions: taper section on both side as per Folio FA166 4- blend transition lines using belt sander with 60 grit sandpaper
120 - 1-Turn second taper on both sides as per Folio FA166 2- Blend transition lines using belt sander with 60 grit sandpaper. 3- Remove sand and plugs 4-Scribe part # and batch # using vibrating stylus
145 - GRIND ONLY TRANSITION LINES SMOOTH LONGITUDE WAY.
150 - 1- handfinish X-TUBE INSIDE AND OUT
170 - LOCATION : LG014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6009-129	Crosstube Material	1 Ea (1 ea)	90-Start up Operation	

B123972

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6009-129	1	103	0

Part Specifications

Specifications could not be found.

Plex 3/2/18 9:55 AM Dart.Gagnon.Michelle



Container No: S083087



Part: D412-664-203TRN

Job No: 173474

Serial No/Batch: S083087

Revision: F

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/21/18

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DART AEROSPACE LTD	Work Order:	173474
Description: Crosstube Assembly (412 High Aft)	Part Number:	D412-664-243
Inspection Dwg: D412-664-243 Rev: F		Page 1 of 2

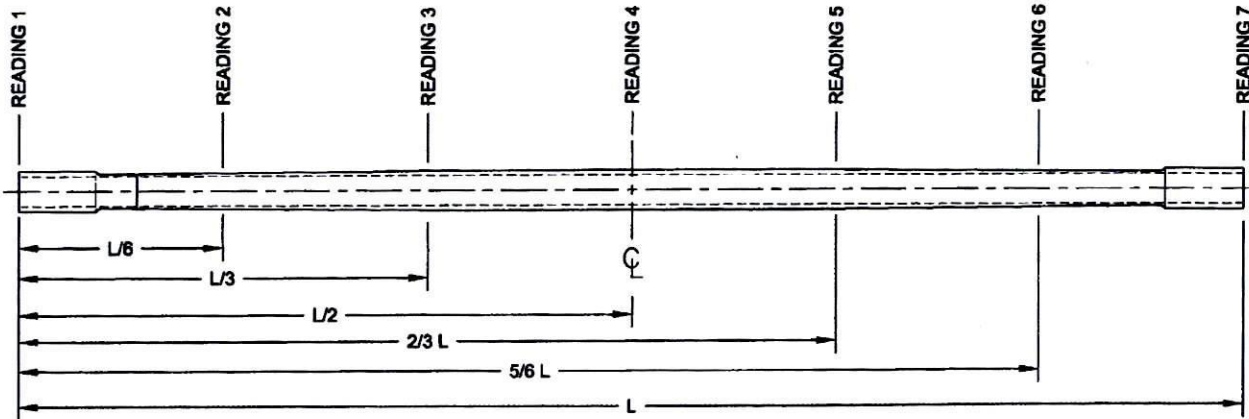
FIRST ARTICLE INSPECTION CHECKLIST

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.684	+0.005/-0.000	2.688	✓		BLM3" 04	
	2.748	+0.005/-0.000	2.752	✓		"	
	2.884	+0.005/-0.000	2.889	✓		"	
	3.019	+0.005/-0.000	3.024	✓		BLM4" 05	
	3.163	+0.005/-0.000	3.167	✓		BLM4" 05	
	3.308	+0.005/-0.000	3.313	✓		BLM4" 05	
	3.429	+0.005/-0.000	3.434	✓		BLM4" 05	
	2.990	+0.005/-0.000	2.9935	✓		BLM3" 04	
	2.618	+0.005/-0.000	2.622	✓		"	
	0.200	+/-0.010	.204	✓		Vern 08	
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		RG	
	4.971	+/-0.030	4.974	✓		Vern 08	
SIDE B	2.684	+0.005/-0.000	2.689	✓		BLM3" 04	
	2.748	+0.005/-0.000	2.753	✓		"	
	2.884	+0.005/-0.000	2.889	✓		"	
	3.019	+0.005/-0.000	3.024	✓		BLM4" 05	
	3.163	+0.005/-0.000	3.168	✓		BLM4" 05	
	3.308	+0.005/-0.000	3.313	✓		BLM4" 05	
	3.429	+0.005/-0.000	3.434	✓		BLM4" 05	
	2.990	+0.005/-0.000	2.995	✓		BLM3" 04	
	2.618	+0.005/-0.000	2.622	✓		"	
	0.200	+/-0.010	.201	✓		Vern 08	
	R0.063	+/-0.010	.063	✓		RG	
	R0.500	+/-0.010	.500	✓		RG	
	4.971	+/-0.030	4.9715	✓		Vern 08	
	124.100	+/-0.020	124.100	✓		tape	

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DART AEROSPACE LTD	Work Order: 173474
Description: Crosstube Assembly (412 High Aft)	Part Number: D412-664-243
Inspection Dwg: D412-664-243 Rev: F	Page 2 of 2

WALL THICKNESS MEASUREMENT



Location	WALL THICKNESS MEASUREMENT (IN)				Deviation Δw (max-min)	TOLERANCE
	w1	w2	w3	w4		
READING 1 L = 0"	.380	.383	.354	.346	.037	0.073"
READING 2 L = 20.683	.286	.304	.322	.306	.036	
READING 3 L = 41.367	.481	.475	.469	.469	.012	
READING 4 L = 62.050	.634	.634	.618	.610	.024	
READING 5 L = 82.733	.467	.478	.500	.488	.033	
READING 6 L = 103.417	.298	.295	.312	.311	.017	
READING 7 L = 124.100	.380	.398	.348	.333	.065	

Calibration Result

Actual Block Thickness: 100-750

Sitescan 250 Measured Thickness: 100-750

DAS
56

9-89

Measured by: M.D.	Audited by: GP 1	Preliminary Approval:
Date: 2018-06-21	Date: 18-06-29	Date:

Rev	Date	Change	Revised by	Approved
A	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	
C	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM	
D	10.02.02	Dimension 124.100 was 124.09	KJ	
E	12.06.04	Wall thickness form added	KJ	
F	14.06.24	Dwg Rev updated	KJ	

SHOP COPY

RETURN TO

ENGINEERING

CONTROLLED COPY

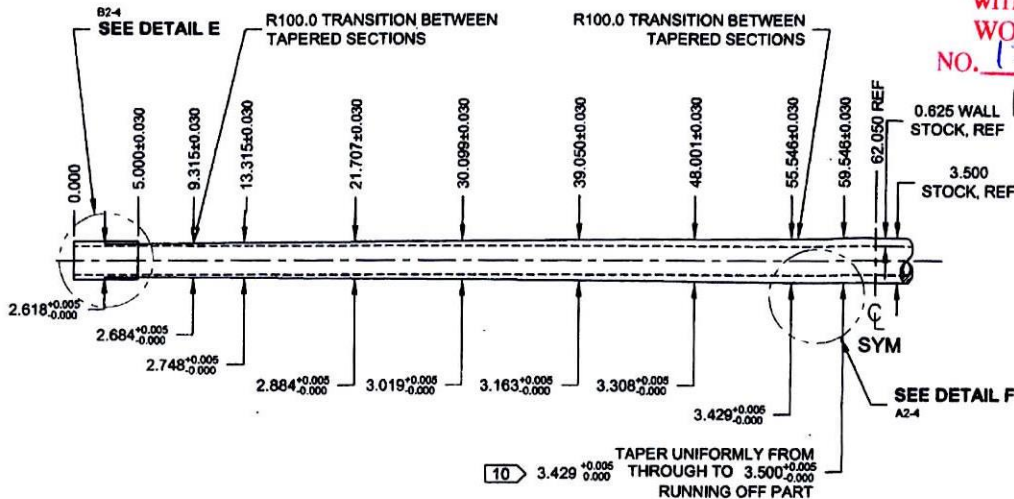
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 173474

MAR 02 2018



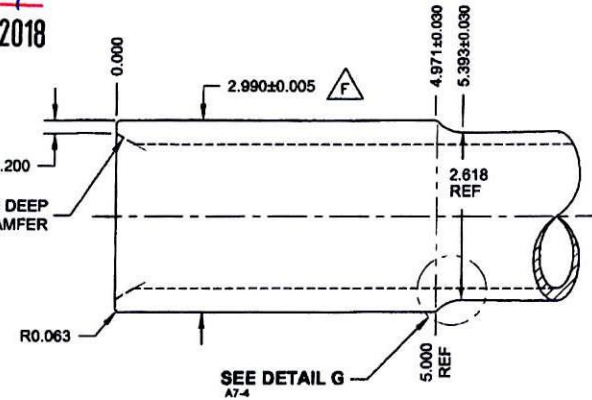
D412-664-243TRN
TURNING DETAIL

0.625 WALL STOCK, REF

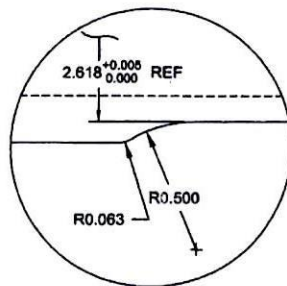
3.500 STOCK, REF

30° X 0.500 DEEP CHAMFER

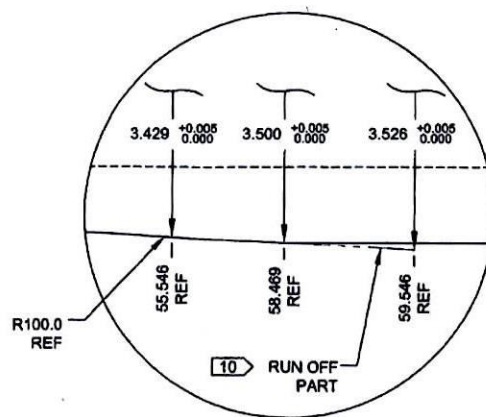
SEE DETAIL F
A2-4



DETAIL E:
CROSSTUBE CUFF
SCALE 5X



DETAIL G:
CUFF TRANSITION
SCALE 10X



DETAIL F:
TAPER RUN-OFF
NOT TO SCALE

RELEASED
2014-05-26

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D412-664-243	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
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